

Work Order ID 56759

Monday, March 08, 2010 10:23:22 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 3/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 10-3-8

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A HJ

110



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

W 10/3/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes, No DQA: _____ Date: _____

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



Skidtubes

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

0.00

S. 10/03/09

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

P

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID
140

Skidtubes

Skidtubes

Operation
DescriptionSet Up/
Run Hours
0.00Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampMemo
1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod *m113207*

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod *m113207*

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

*BE 10/03/11**BE 10/03/11**AWM**10-3-12*

W/O:		WORK ORDER CHANGES					
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Tooling:

Date:

Run Start



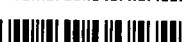
QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

Draw
Number Draw
Rev. Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

S100515

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S100515

(71)

170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

→ M 10/07/23

(X)

O

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M113170

=) 4U 10/03/23

(X1)

0

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 10-3-29

0

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

200



HandFinish

Hand Finishing

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 112409Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 112409Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 113462

BL 10-3-30 ①.

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

210



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

8/6/31

(4)

220



Packaging

Packaging

Packaging

0.00

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev: PA 57237

PC 10/4/15 C

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/15 JF

MF
10-4-15

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Start Date: 3/9/2010

Required Date: 3/24/2010

Comments: IPP Rev:N 102.08.28 FFP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2580-1



Manufactured No

110 Each 6.0000 1.0000



205 Skidtube bent detail

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

LG	6	
54541	2	
56121	2	
<u>56122</u>	2	

D2576-3



Manufactured No

140 Each 130.0000 1.0000



Step (machining detail)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	130	
46661	83	
52215	47	

PR

MO/B18

BE 10/03/11

W/O:		WORK ORDER CHANGES					
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IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

D2579



Manufactured No

140

Each

147.0000 20.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	25	
51525	4	
53780	3	
54543	18	
Main Warehouse		
ST	122	
43988	4	
46434	4	
46956	2	
47797	9	
48272	2	
51314	71	
51315	30	

X

B56145
B56715

x 5
x 15

BE 10/03/11

W/O:		WORK ORDER CHANGES					
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IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

142.0000

1.0000



Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST026	142	
50513	1	
50770	1	
51539	37	
53791	103	

1 Blk 10-3-24

AN3-5A

Purchased No

200

Each

1,405.000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	1405	
100188	188	
105057	1217	

2 Blk 10-3-24.

W/O:		WORK ORDER CHANGES					
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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L



Purchased No

200 Each

3,113.000 2.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>

Main Warehouse

ST	3113
101291	16
105793	49
110985	3048

ALS7-1032-130



Purchased No

200 Each

986.0000 50.0000



Insert

ALS4-1032-130

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

<u>Location</u>

Main Warehouse

ST	986
108606	52
111529	130
111779	34
112772	11
113238	759

2 bl 10-3-24

50. bl 10-3-24

W/O:		WORK ORDER CHANGES					
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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C4A



Purchased

No

200

Each

1,499.000 50.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1499	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226	344	
113644	12	
113749	48	
114103 ✓	500	
114108	500	

50 · Bl 10-3-24

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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

AN960C10L



Purchased No

200

Each

388.0000

50.0000



washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OFFSHORE		
FG	113691	50 Bl 10-3-26.
103585	100	
100		
Main Warehouse		
ST	288	
112116	128	
112612	160	

D3566-13



Manufactured No

200

Each

72.0000 1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
FP	70	
53461	70	1 Bl 10-3-24.
Main Warehouse		
ST	2	
45717	1	
50265	1	

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IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

D3566-5



Manufactured No

200

Each

23.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19	19
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55026	7
-------	---

55335 ✓	12
---------	----

Main Warehouse

ST	4
----	---

36113	1
-------	---

46186	1
-------	---

47318	1
-------	---

51260	1
-------	---

1 Bl 10-3-24

W/O:		WORK ORDER CHANGES					
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Start Date: 3/9/2010

Required Date: 3/24/2010

Comments: IPP Rev:N 10.02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

D3566-1



Manufactured No

200

Each

13.0000

2.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP 56532

8

2

BL10-3-24

52512

54480

55011

55320

Main Warehouse

ST

5

46349

51218

51259

D3564-11



Manufactured No

200

Each

9.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP19 56834

7

55332

Main Warehouse

ST

2

45823

50112

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

Monday, March 08, 2010 10:23:22 AM

Work Order ID: 56759



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/9/2010

Required Date: 3/24/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

33.0000

1.0000

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP17

21

56285 ✓

21

1 Blk 10-3-24

Main Warehouse

ST

12

45409

2

46495

10

D3564-9

Manufactured No

200

Each

18.0000

1.0000

Wearshoe



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP19

16

55025

4

55334 ✓

12

1 Blk 10-3-24

Main Warehouse

ST

2

44659

1

45825

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

Monday, March 08, 2010 10:23:22 AM

Work Order ID: 56759



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/9/2010

Required Date: 3/24/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5



Manufactured No

200

Each

33.0000

1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	29	
51925	1	
54772	4	
55024	12	
55333	12	
Main Warehouse		
ST	2	
45824	1	
47433	1	

10-3-24.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 11

Monday, March 08, 2010 10:23:22 AM

Work Order ID: 56759



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/9/2010

Required Date: 3/24/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

D2594-3



Manufactured No

200

Each

508.0000 16.0000



O-Ring, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	495	
51613 ✓	27	
55546 ✓	468	
Main Warehouse		
ST	13	
52562	13	

16 Bk 10 3-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

Monday, March 08, 2010 10:23:22 AM

Work Order ID: 56759



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/9/2010

Required Date: 3/24/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-1



Manufactured No

200

Each

577.0000 16.0000



Plug, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

FP	449	
54008	1	
54643	15	
55002 ✓	433	

16 BL 10-3-24

Main Warehouse

ST	128	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2580	SHEET 1 OF 3
DATE		TITLE	SCALE
07.02.27		205 SKIDTUBE ASSEMBLY	NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AEIS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

#56759

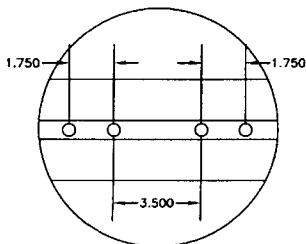
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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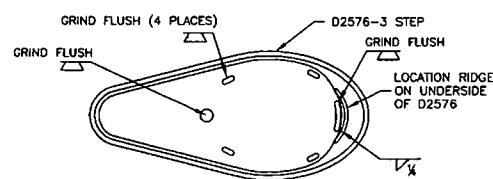
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DETAIL E
SCALE 5:24

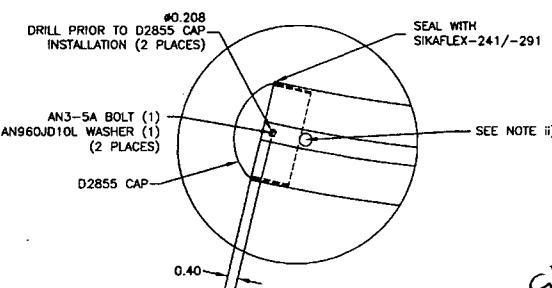


RELEASED
07/26/28

DETAIL F
SCALE 5:24

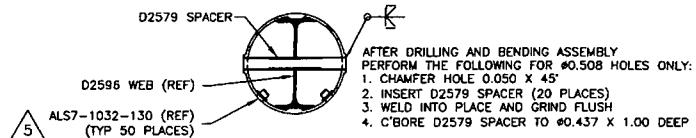


DETAIL G
SCALE 5:24



b5L9S

SECTION H-H
SCALE 5:24

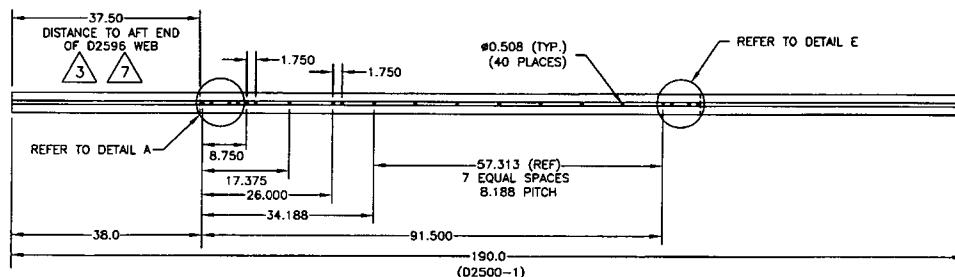


C

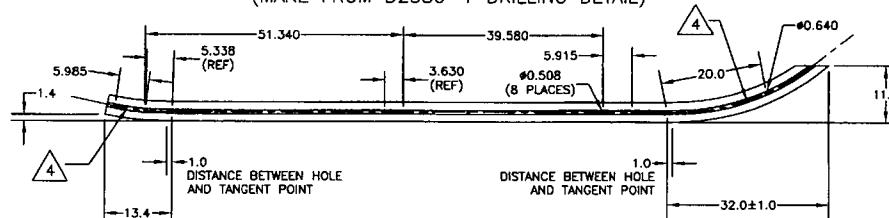
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

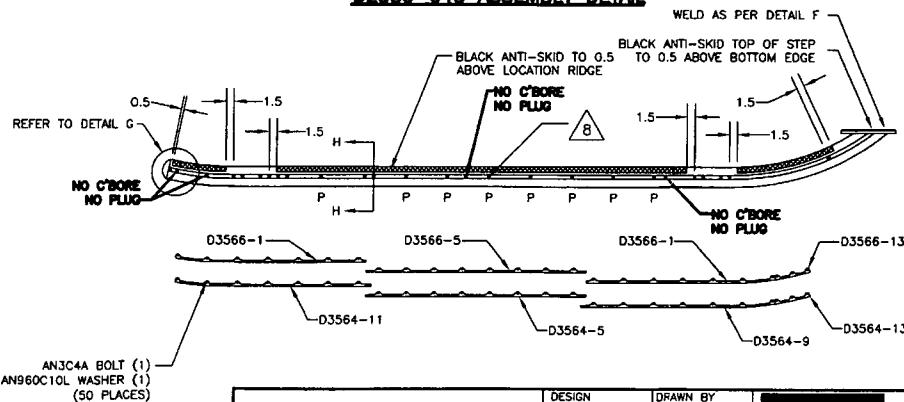
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN

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RH

DART

DART AEROSPACE LTD.

HAWTHORPE, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

D2580

DATE

07.02.27

REV. 0

SHEET 3 OF 3

SCALE

1:24

TITLE

205 SKIDTUBE ASSEMBLY

NO. 226

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 56134
Part number: D205 634.041
Description: 205 skid tube
Welding Process: Tig Mig
Base materiel: Aluminum
Current: AC DC

TEST REQUIREMENTS AND RESULTS

Visual: pass fail
Penetration: pass fail

UNACCEPTABLE

Cracks: pass fail
Undercut: pass fail
Pin holes: pass fail
Overlap (cold lap) pass fail
Porosity (surface): pass fail
Coloration: pass fail

Qualifier Barclay Elliott Date of Test Coupon 10-02-23
Welder Barclay Elliott Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld